



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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RBT400214-9
Job Sheet 189150



Part No: RBT400214-9

Job Qty: 10 pcs

DAS
21
9-59

Part Name: Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT400214 Rev.7 IPP Rev. A 18.06.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
120	NV5000 - 1	10 pcs	2/15/19	2/15/19	0.50 2.50	NV5000 - 1		PS 19-06-19 S.C.L.
						NV5000 - 2		
130	QC 2	10 pcs	2/15/19	2/15/19	0.00 0.00	QC 2 - 1		PS 19-06-19
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		
						QC 2 - 32		S.C.L. 19-06-20
						QC 2 - 33		
						QC 2 - 35		
						QC 2 - 38		
						QC 2 - 39		
						QC 2 - 4		
						QC 2 - 40		
						QC 2 - 44		
						QC 2 - 45		
						QC 2 - 48		
						QC 2 - 49		
						QC 2 - 50		
						QC 2 - 51		
						QC 2 - 52		
						QC 2 - 54		
						QC 2 - 56		
						QC 2 - 57		
						QC 2 - 62		
						QC 2 - 63		



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Container No: S192220



Part: RBT400214-9

Job No: 189150

Serial No/Batch: S192220

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 06/20/19

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DAS
03
9-88

DAS
03
9-88

				QC 2 - 8	
140	Conventional Mill - 1 - B4B	10 pcs	2/15/19	0.00 2.00	Conventional Mill - 1 - B4B
	N/A				Conventional Mill - 2 - B4B
150	QC 2	10 pcs	2/15/19	0.00 0.00	QC 2 - 1
	N/A				QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 38
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 54
					QC 2 - 56
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
160	QC 8	10 pcs	2/15/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
170	Packaging 3-1 - Stock - B4B	10 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B

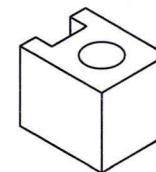
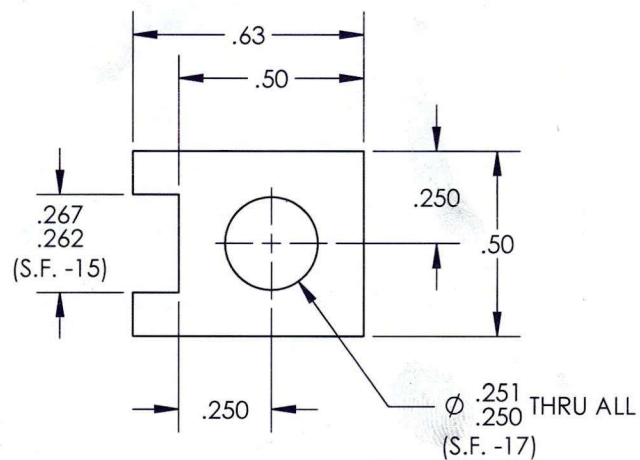
man 19/06/20

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	W
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	DAG 21 JUN 21 2019
				QC 21 - SA - 70	
Part Op 120 - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) ***Cut blanks to 5.50" long*** 1 BLANK MAKES 6 PARTS*** 1- Descriptions: Machine as per folio FC319 FOLIO REV: <u>AA</u> DWG REV: <u>T</u> 2-Debur 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (Manufacture as per dwg) 1-Machine as per DWG. 2-Debur 150 - (QC2- Inspect parts off machine FAI/FAIB) 160 - (QC8- Inspect parts - second check) 170 - (Identify as per dwg & Stock Location: <u>WARB-05</u>) IDENTIFY AND STOCK 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B0.500X00.750	6061T6 Bar 0.500 X 0.750	4.5800 ft (.458 ea)	120-NV5000 - 1	50 P7595	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-NV5000 - 1	M6061T6B0.500X00.750	5	18	0	
Part Specifications					
Specifications could not be found.					

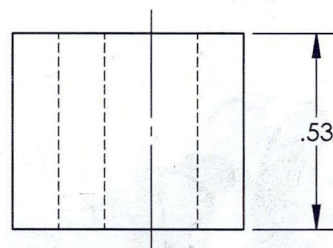
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		-9 CH'D DIM WAS .250 IS .250 +.005/- .000.	2/26/2013	BIM	SE
6		-9 CH'D DIM WAS .500 IS .530.	3/22/2013	BIM	GE
7	16-0240	-9 CH'D DIMS WAS .500 IS .50, WAS .530 IS .53, WAS .250 +.005-.000 S.F. -13 IS .262-.267 (S.F. -15), WAS .625 IS .63, WAS .500 IS .50, WAS Ø.250 IS Ø.250-.251 THRU ALL (S.F. -17).	12/1/2016	DPD	JAG



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189150 MLS
(9-01-1)



(-9)
ADAPTER

DART AEROSPACE	
TITLE TRIM TAB BENDING GAUGE	
DWG NO. RBT400214-9	REV 7
MAT'L 6061 HEAT TREAT FINISH SEE -1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: COLE CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL BELL 407	
SCALE 2:1	DATE 4/9/2001 SHEET 6 OF 11

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					